



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2600-3-BENT-LH**Job Sheet 200649****Part No:** D2600-3-BENT-LH**Job Qty:** 12 pcs**Part Name:** Extrusion Bent LH**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 9/13/19**Job Tracking No:****Due Date:** 10/14/19**Created By:** Marie Lajeunesse**Type:** Stock**Description:****Note:** DWG D2750 REV G SHEET 4, D2600 REV E SHEET 2 IPP REV:A 14.01.14 NEW ISSUE DD VERF:JLM**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Skidtubes - Bend - 1	12 pcs	10/14/19	10/14/19	0.20	3.86	Skidtubes - Bend		
110	QC 5	12 pcs	10/14/19	10/14/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
120	Packaging 3-1 - Stock - B4B	12 pcs	10/14/19	10/14/19	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		
							Packaging 3 - 8 - B4B		
							Packaging 3 - 9 - B4B		
							Packaging 3 - 10 - B4B		
							Packaging 3 - 11 - B4B		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL : 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S216547**Part:** D2600-3-BENT-LH**Job No:** 200649**Serial No/Batch:** S216547**Revision:****Inspector:****Exp Date:****Instructions:****Date:** 09/24/19

Plex 9/13/19 1:26 PM Dart.lajeunesse.marie

9/13/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	BB
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
130 QC 21 - SA	12 pcs	10/14/19	0.00 0.00	QC 21 - SA - 21	21
				QC 21 - SA - 70	21
				QC 21 - SA - 53	21

SEP 26 2019

Part Op 100 - (CNC Delta 100 Bender) Pick qty 1 D2600-3-130 extrusion 1-Deburr one end of extrusion 2-Bend using CNC
 Descriptions: bending machine as per program 2750.C and Folio 14 use bending aid DT9635 3- cut fwd end of tube as per dwg D2750
 4- cut aft end of tube as per dwg D2750
 110 - (QC5- Inspect part completeness to step on W/O)
 120 - (Identify as per dwg & Stock Location: LG002) LOCATION : LG002
 130 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2600-3-130	Extrusion Round 3" 350	12 pcs (1 ea)	100-Skidtubes - Bend - 1	5124531

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Skidtubes - Bend - 1	D2600-3-130	12	55	0

Part Specifications

Specifications could not be found.

Plex 9/13/19 1:26 PM Dart.lajeunesse.marie

SPECIFICATION CONTROL DRAWING

D2600-X-XXX EXTRUSION



NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM PER QQ-A-2008 OR AMS-QQ-A-2008 OR ASTM B221
 MINIMUM TENSILE YIELD STRENGTH = 35 KSI
 MINIMUM ULTIMATE TENSILE STRENGTH = 40 KSI
 MINIMUM ELONGATION = 8%
 A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE ABOVE MINIMUM MECHANICAL PROPERTIES
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N & B/N PER DART QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
- 7) WEIGHT: D2600-1 = 0.078 lb/in, D2600-3 = 0.130 lb/in, D2600-5 = 0.045 lb/in, D2600-7 = 0.081 lb/in
- 8) NO TOOLING MARKS
- 9) FOR D2600-1, PART NUMBER IS D2600-1-XXX WHERE XXX IS CUT LENGTH (EX. D2600-1-180 IS 180" LONG).
 D2600-1 EXTRUSION MANUFACTURED FROM:
 - CARADON INDALEX DIE # MH-18870
 - SIGNATURE ALUMINUM (BON-L) DIE # 887121
- 10) FOR D2600-3, PART NUMBER IS D2600-3-XXX WHERE XXX IS CUT LENGTH (EX. D2600-3-120 IS 120" LONG).
 D2600-3 EXTRUSION MANUFACTURED FROM:
 - CARADON INDALEX DIE # MH-18859
 - SIGNATURE ALUMINUM (BON-L) DIE # 887122
- 11) FOR D2600-5, PART NUMBER IS D2600-5-XXX WHERE XXX IS CUT LENGTH (EX. D2600-5-108 IS 108" LONG).
 D2600-5 EXTRUSION MANUFACTURED FROM:
 - CARADON INDALEX DIE # MS-18871
- 12) FOR D2600-7, PART NUMBER IS D2600-7-XXX WHERE XXX IS CUT LENGTH (EX. D2600-7-125 IS 125" LONG).
 D2600-7 EXTRUSION MANUFACTURED FROM:
 - CARADON INDALEX DIE # MS-18872

UNCONTROLLABLE
SUBJECT

NO. 200649 MWS
(409-73)

RELEASED
2012-01-11

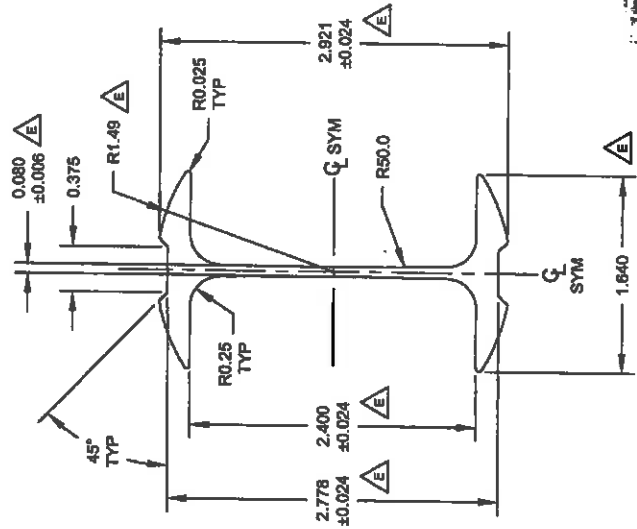
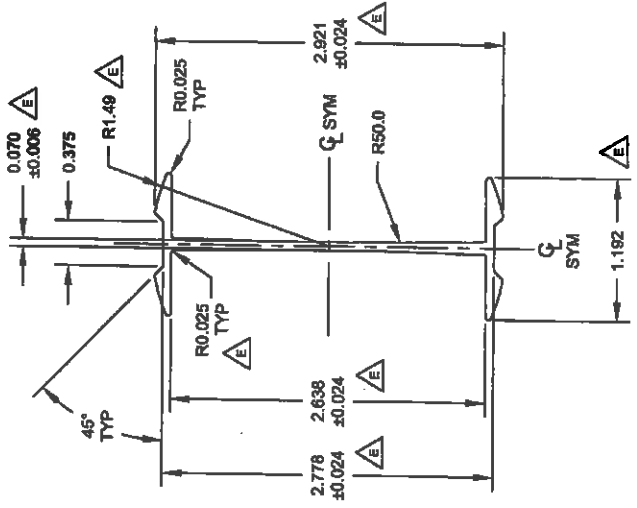
REV.	DESCRIPTION	BY	DATE
E	REFORMAT DWG; ALL DIMS & TOL. UPDATE TO MATCH MFG DIE DWGS; ADD ASTM B221 SPEC (08-1)	CP	11.10.18
D	INCREASE MIN. UTS TO 40 KSI	DS	98.08.20
C	ADD D2600-3, UPDATE D2600-1 WIDTH, ADD DIE NO.	DS	98.04.16
B	CHANGE MATERIAL SPEC.	DS	97.09.09
A	NEW ISSUE	DS	97.01.21
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DIE APPR.			
DATE	11.10.18		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. E SHEET 1 OF 3
DRAWING NO. D2600	SCALE NTS
TITLE EXTRUSION	NTS
DATE 11.10.18	NTS

COPYRIGHT © 1997 BY DART AEROSPACE LTD
ALL RIGHTS RESERVED. NO PART OF THIS PUBLICATION MAY BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE LTD.

8 7 6 5 4 3 2 1

D C B A

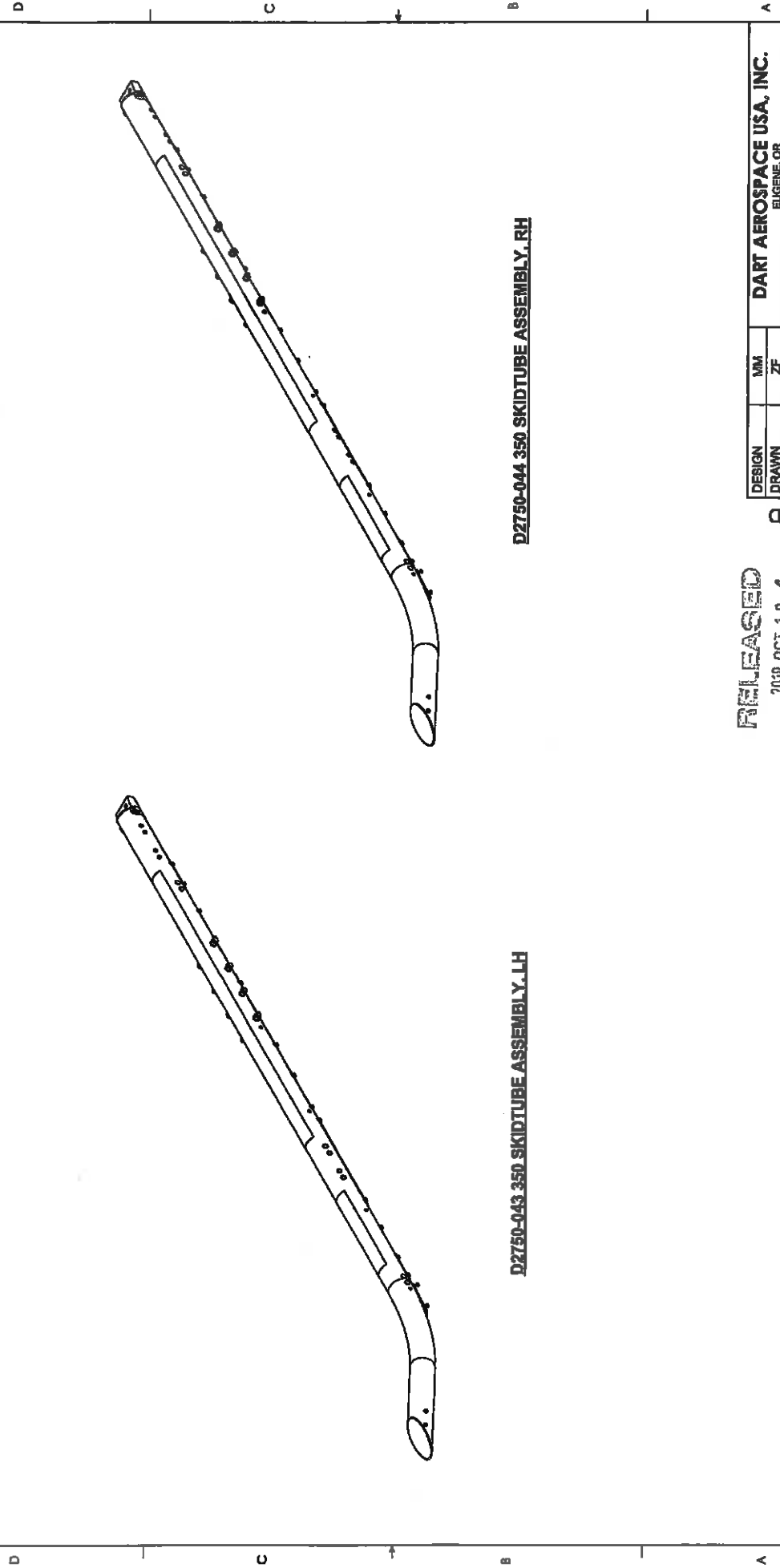


RELEASED
10-11-10

DESIGN	4	DART AEROSPACE LTD	REV. E
DRAWN	0	HAWKESBURY, ONTARIO, CANADA	SHEET 3 OF 3
CHECKED	ASS	DRAWING NO.	SCALE
MFG. APPR.	DE	D2600	NTS
APPROVED	DE	TITLE	EXTRUSION
DATE	11.10.18	DATE	DATE

8 7 6 5 4 3 2 1

1 2 3 4 5 6 7 8



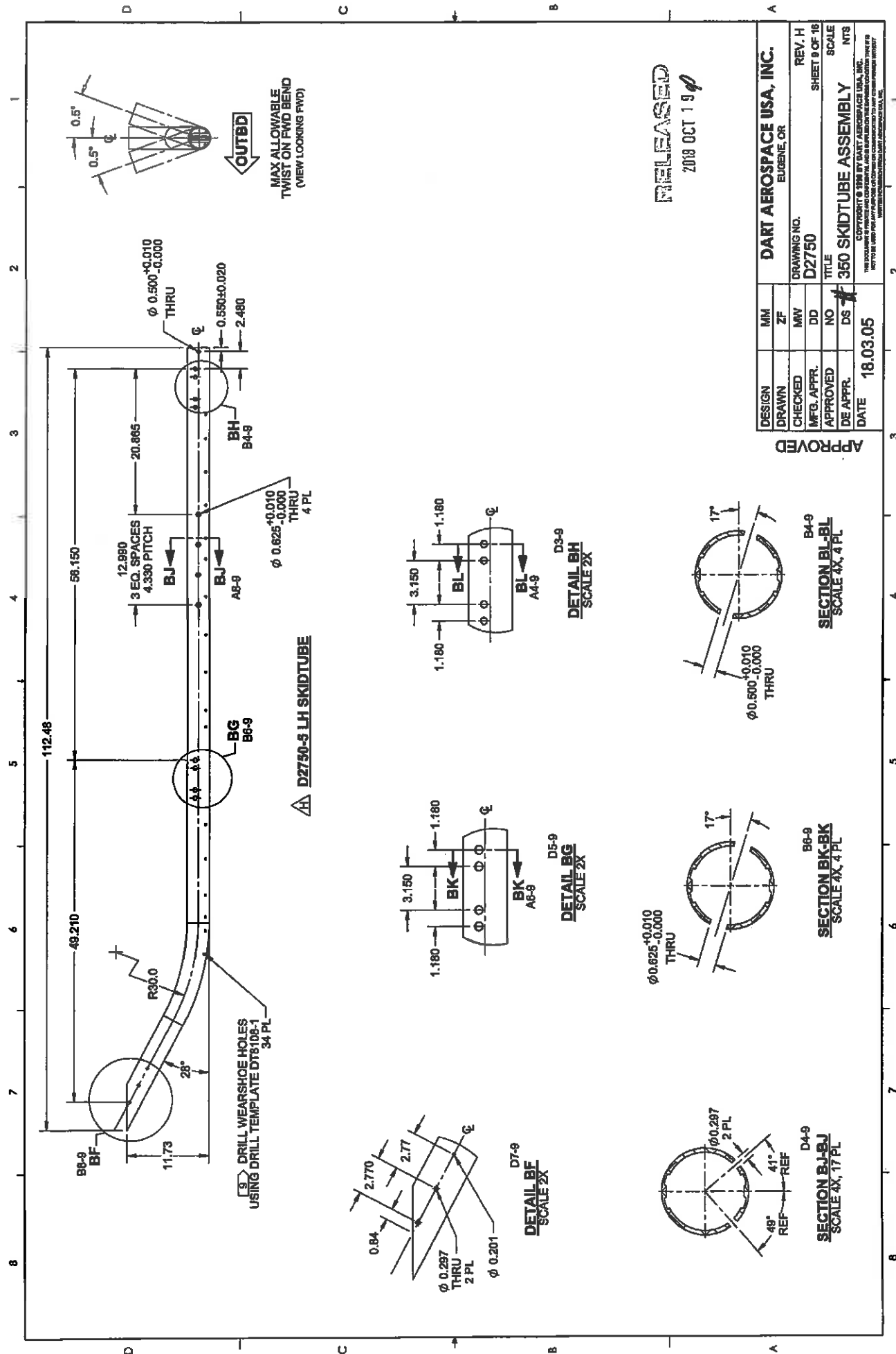
D2750-044 350 SKIDTUBE ASSEMBLY, RH

D2750-043 350 SKIDTUBE ASSEMBLY, LH

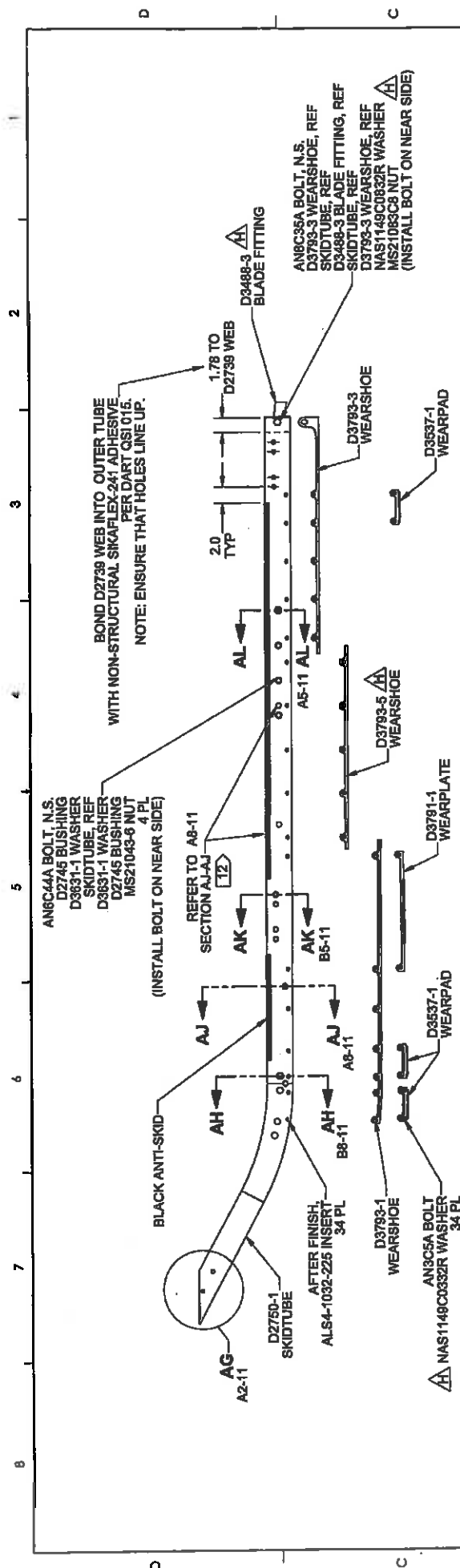
RELEASED
2018 OCT 19

APPROVED

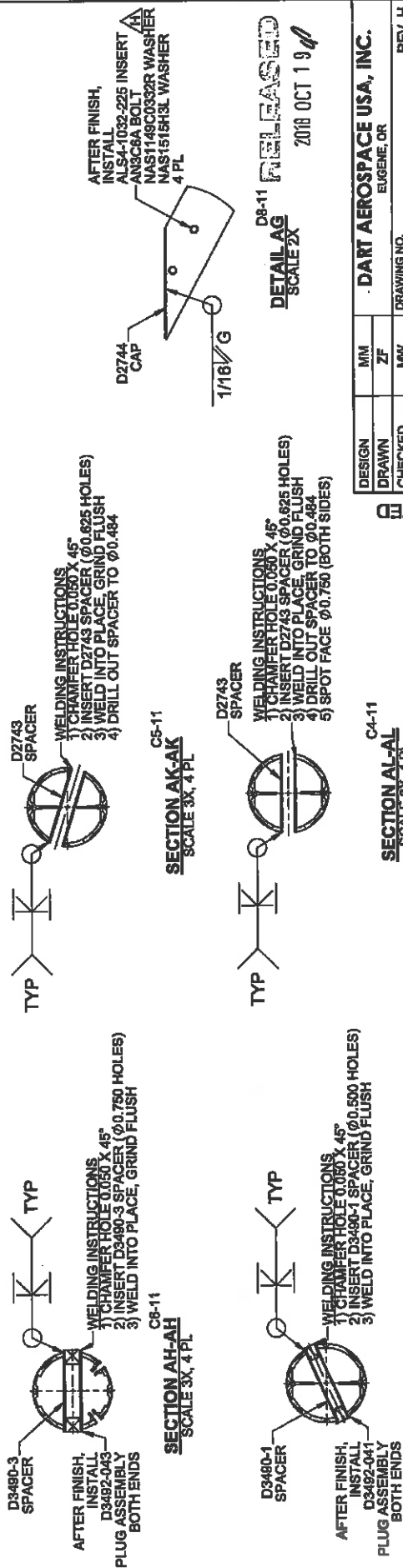
DESIGN	MM	DART AEROSPACE USA, INC.	
DRAWN	ZF	EUGENE, OR	
CHECKED	MW	DRAWING NO.	REV. H
INFG. APPR.	DD	D2750	SHEET 3 OF 16
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	350 SKIDTUBE ASSEMBLY	NTS
DATE	18.03.05	COPYRIGHT © 1988 BY DART AEROSPACE USA, INC.	
THE INFORMATION CONTAINED HEREIN IS UNCLASSIFIED EXCEPT WHERE SHOWN OTHERWISE			



RELEASED
2018 OCT 19



D2750-041 350 SKIDTUBE ASSEMBLY.LH



DESIGN	MM	DART AEROSPACE USA, INC. EUGENE, OR	REV. H SHEET 11 OF 16
DRAWN	ZF		
CHECKED	MM		
MFG. APPR.	DD		
APPROVED	NO		
DE APPR.	DS	350 SKIDTUBE ASSEMBLY CANNON & NEWPORT ASSOCIATES, INC. THIS DOCUMENT IS UNCLASSIFIED AND CONTAINS NO INFORMATION THAT IS NEITHER REQUIRING PROTECTION NOR IS NEITHER REQUIRING PROTECTION NOR IS NEITHER REQUIRING PROTECTION	SCALE NTS
DATE	18.03.05		

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

NCR No. _____

Job: _____ Part No. _____		DISPOSITION Rework ☐ ☐ ☐ Scrap ☐ ☐ ☐ Use-as-is ☐ ☐ ☐		DEPARTMENT/PROCESS Skid-tube ☐ ☐ ☐ ☐ ☐ Machining ☐ ☐ ☐ ☐ ☐ Large Fab ☐ ☐ ☐ ☐ ☐ Cross tube ☐ ☐ ☐ ☐ ☐ Small Fab ☐ ☐ ☐ ☐ ☐ Finishing ☐ ☐ ☐ ☐ ☐ Eng. (Non-AW) ☐ ☐ ☐ ☐ ☐ Prod. Eng. Coord. ☐ ☐ ☐ ☐ ☐ Rec/Store/Packaging ☐ ☐ ☐ ☐ ☐ Engineering ☐ ☐ ☐ ☐ ☐ Water Jet ☐ ☐ ☐ ☐ ☐ Supplier ☐ ☐ ☐ ☐ ☐ Quality ☐ ☐ ☐ ☐ ☐		MRB (QS042)	
Date: _____		Sequence #: _____		QTY Affected: _____			
Description Work Order Deviation		Disposition		Completed By			
Pressure/Forced Bending Crushing Cracks Crimp/Kink/Ripple/Wave/Twist Marks/Chatter Mislabeled Other/Details:		Contamination Misaligned/off center BOM/Route Broken/Damage/Defect Incomplete/Unclear Instructions Drill Holes Fit/Function		Power Loss/Surge Folio/Program Grain Direction Weld Wrong Stock Pulled Out of Sequence Off-set/Set-up			
Root Cause Operator ☐ ☐ ☐ ☐ ☐ Manufacturing Process ☐ ☐ ☐ ☐ ☐ Equip/Tooling ☐ ☐ ☐ ☐ ☐ Handling/Preservation ☐ ☐ ☐ ☐ ☐ Material ☐ ☐ ☐ ☐ ☐ Product Improvement ☐ ☐ ☐ ☐ ☐ Process Improvement ☐ ☐ ☐ ☐ ☐ Human Factors ☐ ☐ ☐ ☐ ☐		Positioned Wrong Outside Tolerance Drawing Finish Part Lost/Missing Misread		QC / QA Coordinator			
Lead hand / Supervisor		QC / QA Coordinator		QC / QA Coordinator			